
Page 1

Accept

**Setup Start**

Stop


**Cust Item ID:**

Required Date: 1/19/2011 **Req'd Qty:** 20.00

[illegible]

Customer:

Reference:



Date: 10-02-17

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

100	Hardinge CNC LATHE SMALL	0.00	20	0
Hardinge	Memo	0.00		
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO F970 & DWG D3622, FOLIO REV: <u>C</u> DWG REV: <u>SA</u> 10/12/22 2-DEBURR AS REQUIRED			
110	QC2- Inspect parts off machine FAI/FAIB	0.00	20	0
QC	Memo	0.00		
Quality Control	SA 10/12/22			
120	QC8- Inspect parts - second check	0.00	20	0
QC	Memo	0.00		
Quality Control	amk 10/12/22			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64806

Friday, December 17, 2010 7:58:45 AM



Page 2

Item ID: D3622-13

Accept



Setup Start



Revision ID:

Item Name: Ball Stud

Stop



Start Date: 12/16/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: 070

0.00

Memo

0.00

Packaging

12/16/23 (20)

140



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/23 (20)

10/12/23 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 7:58:49 AM

Page 1

Work Order ID: 64806

Parent Item: D3622-13

Parent Item Name: Ball Stud




Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500  303 HEX BAR .500		Purchased	No			100	f	119.1480	0.108	2.273684			



10/12/22

Location

Loc Qty

Loc Code

MAT037

119.148

109778

99.548

109846

19.6

2.54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64806
Description: Bell STD		Part Number: A3622-13
Inspection Dwg: A3622 Rev: C		Page 1 of 1

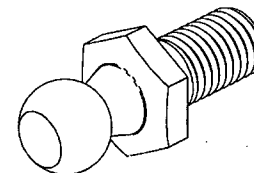
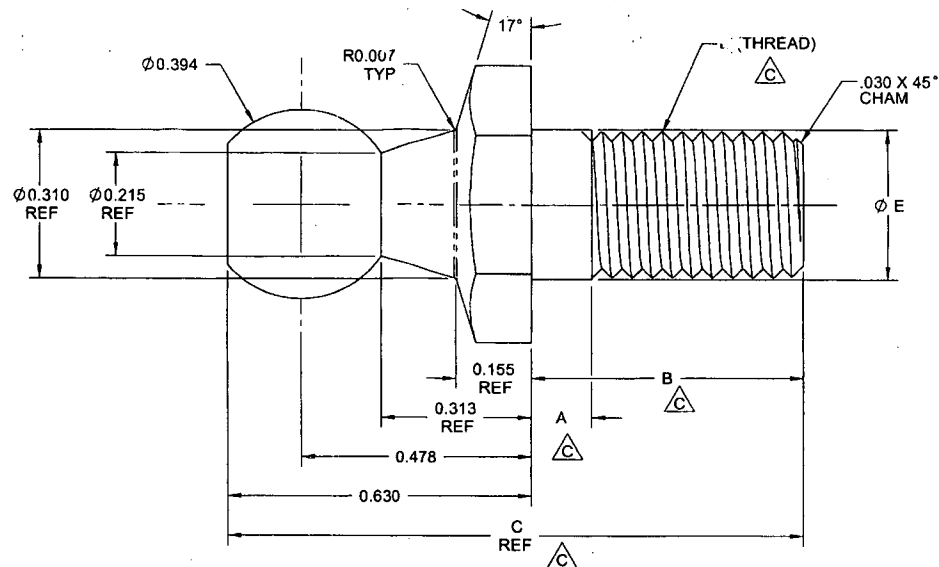
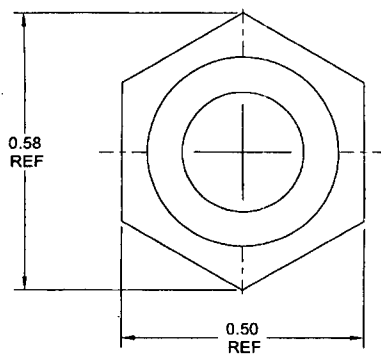
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

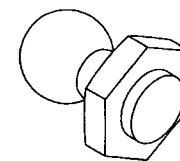
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.58	$\pm .030$.570	/		Ueln	SA-9
.500	$\pm .030$.500	/			
$\emptyset .310$	$\pm .010$	$\emptyset .310$	/		Mic	SA-5
$\emptyset .215$	$\pm .010$	$\emptyset .215$	/			
$\emptyset .394$	$\pm .010$	$\emptyset .394$	/			
1.31	$\pm .030$	1.311	/		Ueln	
.680	$\pm .010$.680	/			
.090	$\pm .010$.085	/			
.630	$\pm .010$.633	/			
.3053 / .3125	N/A	.308	/		Mic	
M.O.W. .3336 / .3363		.334	/		Mic	
.3125-24 UNF-3A	N/A		/			

Measured by: SA	Audited by: amf	Prototype Approval:	N/A
Date: 10/12/22	Date: 10/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E	
						MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

- NOTES:**
 1) MATERIAL: AISI 303 HEX BAR
 REF DART SPEC M303HC.500
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
 7) WEIGHT: SEE D3622-X TABLE

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 64806

C	SHEET 1: ADD -5, -7, -8, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. D3622	
CHECKED		REV. C	
MFG. APPR.		SHEET 1 OF 1	
APPROVED		TITLE	
DE APPR.		BALL STUD	
DATE	10.07.20	SCALE	
NTS			
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2/10/12-17

W/O:		WORK ORDER CHANGES					
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